

Date: Wednesday, 05/11/2008 3:24:06 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LH STEP ACTUATOR ASSEMBLY
Job Number : 43221	
Estimate Number : 12758	
P.O. Number :	Part Number : 41232 000 001 001
This Issue : 05/11/2008 S.O. No. :	Drawing Number : 41232-000-001 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 39167	Material :
Written By :	Due Date : 20/11/2008 Qty : 2 Um : Each
Checked & Approved By : <u>JLD 08.11.05</u>	
Comment : Est Rev:A New Issue 07-02-28 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.11.11

**Comment:** DOCUMENT CONTROL

Photocopy bluefile D412-763 & type labels per PPP 41232-000-001 CHG 002

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	AP0925ELBN	BARBED ELBOW
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

BARBED ELBOW

Batch: M103683

sq

4.0	AN960JD416	Washer
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Batch: M108827

sq

5.0	MS21042L4	Nut
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: M108145

8/11/10

sq

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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6.0	AN423A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M107378

SP

7.0	MS3548993	GROMMET
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

GROMMET

Batch: M106168

SP

8.0	AN960JD416L	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

SP

9.0	MS24665151	Cotter Pin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cotter Pin

M14526

SP

10.0	MS203923C21	Pin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

M104154

SP

11.0	R 3400	plastic tubing 1/4id x 3/8od-black
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Comment: Qty.: 3.0500 f(s)/Unit Total : 6.1000 f(s)

plastic tubing 1/4id x 3/8od-black

Cut to 18" long X2

Batch: M104229

5 X2
memo

SP

12.0	41232 200 006 001	Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket

Batch: B30505

8/11/10

(2x)

SP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #: Machine Or Operation: Description :

13.0 41232 200 005 001 Spacer (Step Actuator)



43253
43253



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)
Spacer (Step Actuator)
Batch: ~~132501~~

B43253

14.0 41232 200 004 001 Reducer Tee Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Reducer Tee Assembly
Batch: B31779

15.0 41232 200 003 001 Spring (Step Actuator)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Spring (Step Actuator)
Batch: B30941

16.0 41232 200 001 001 Step Actuator LH Ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Step Actuator LH
Batch: B42218

8/11/11

17.0 124K002 4CR 0545 Hose ass'y-Step Actuator



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Hose ass'y-Step Actuator
BATCH: M104384

M104042

8/11/10

18.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08.11.11 (2)

19.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP 41232-000-001-001

Location: 10

PPP Rev: B

8/11/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:


Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08.11.11 

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.11.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REVISION					
LETTER	DFTSMAN	DATE	DESCRIPTION	APPROVED	DATE
A	DNN	1/14/04	INCRP. E.O.; CHG. P/N OF ITEM #17. MINOR CHANGE - FAR 21.95	1/14/04	1/14/04

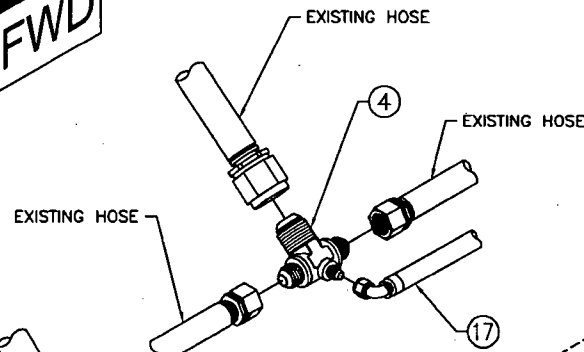
A

			1	1	17	PS4025E000DF540A	HOSE					
			1	1	16	AP0925ELBN	BARBED ELBOW	ARK-PLAS PRODUCTS, INC., FLIPPIN, ARKANSAS 72634				
			2	2	15	AN960JD416	WASHER					
			1	1	14	MS21042-L4	NUT					
			1	1	13	AN4-23A	BOLT					
			AR	AR	12	MIL-S-8802	SEALANT					
			1	1	11	MS35489-93	GROMMET					
			2	2	10	AN960JD416L	WASHER					
			1	1	9	MS24665-151	COTTER PIN					
			1	1	8	MS20392-3C21	PIN					
			2	2	7	R-3400 1/4 ID x 3/8 OD BLACK	PLASTIC TUBING	NORTON PERFORMANCE PLASTICS CORP., AKRON, OHIO 44309				
			1	1	6	41232-200-006-001	BRACKET	(ALT. P/N 412-050-026-101, BELL HELICOPTER)				
			3	3	5	41232-200-005-001	SPACER					
			1	1	4	41232-200-004-001	REDUCER TEE					
			1	1	3	41232-200-003-001	SPRING					
			1		2	41232-200-001-002	R/H ACTUATOR ASSY					
				1	1	41232-200-001-001	L/H ACTUATOR ASSY					
						-002	R/H INSTALLATION					
						-001	L/H INSTALLATION					
			-002	-001	FRD NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE	

NO. REQ'D PER ASSY		LIST OF MATERIAL		DFTSMAN D. NELSON 5/20/02		TITLE STEP ACTUATOR INSTALLATION	
UNLESS OTHERWISE SPECIFIED		CHECK D. MURPHY 5/20/02		DFTSMAN		SCALE NONE	
X1.1				DFTSMAN		DWR. SIZE C	
X100.03				CHECK		SCALE NONE	
X100.010				STRESS		DWR. NO. 41232-000-001	
ANGLES ±1/2°				FINISH		SHT 1 OF 2	
41232-1000				FRA Aviation, Inc.		REV. A	
NEXT ASSEMBLY							

SHOP COPY
 RETURN TO
 ENGINEERING
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 43221

FWD



L/H STEP

L/H SKID TUBE

16 INSTALL ELBOW IN EXISTING SKID TUBE HOLE PREVIOUSLY USED FOR ELECTRICAL WIRE.

412-050-017-133 COVER (REF.)

17 EXISTING FLOAT BAG
ROUTE HOSE THROUGH FLOAT BAG ATTACHMENT ALONG SIDE OF EXISTING HOSE.

EXISTING HOSE
RETAINER (REF.)
SCREW (REF.)

TORQUE SCREWS TO 12-15 INCH LBS.

6 BRACKET MUST BE INSTALLED AS SHOWN

FWD

VIEW LOOKING INBOARD

001 L/H INSTALLATION (SHOWN)
002 R/H INSTALLATION (OPPOSITE)

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Era Aviation, Inc.

STEP ACTUATOR INSTALLATION

REV.	41232-000-001	REV.
C	SHT 2 OF 2	A

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